

Work Order ID 81129

81129

Page 1

March-08-12 1:32:37 PM

Item ID: D4000-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 08/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 22/03/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/08 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4000	A								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
<u>6061 .032</u>	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B12-3-9

(3)

B12-3-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81129

March-08-12 1:32:37 PM

81129

Page 2

Item ID: D4000-11

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cap

Stop ***NS2***

Start Date: 08/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: ST WA 0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

30X SP 12-03-12. SP.

12/3/12
MF
12-03-12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March-08-12 1:32:40 PM

Page 1

Work Order ID: 81129

81129

Parent Item: D4000-11

D4000-11

Parent Item Name: Cap

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev A 10.02.03 new issue Prelim EC verified by:DD IPP rev B
10.05.13 ecn10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	149.8860	0.001	0.012	.5		

M6061T6S 032

6061-T6 Sheet 0.032"

**

1812-3-9

Location

Loc Qty

Loc Code

MAT021

149.886

118106

48.606

120218

47.6

120285

53.68

120218

32

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NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

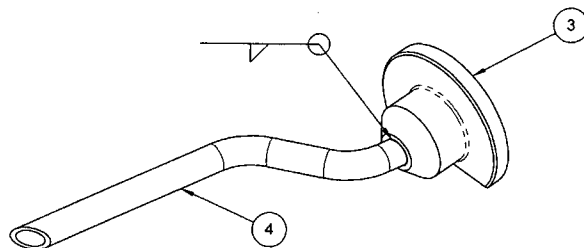
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NOTE: Date & initial all entries

ITEM	QTY. -043	QTY. -045	P/N	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X		D4000-041	DRAIN FITTING ASSEMBLY, AFT	JCA-M47-1-06
2		X	D4000-043	DRAIN FITTING ASSEMBLY, FWD	JCA-M47-1-15
3	1	1	D4000-3	FUEL SUMP DRAIN FITTING	
4	1		D4003-1	INTERNAL DRAIN LINE, AFT	
5		1	D4003-3	INTERNAL DRAIN LINE, FWD	

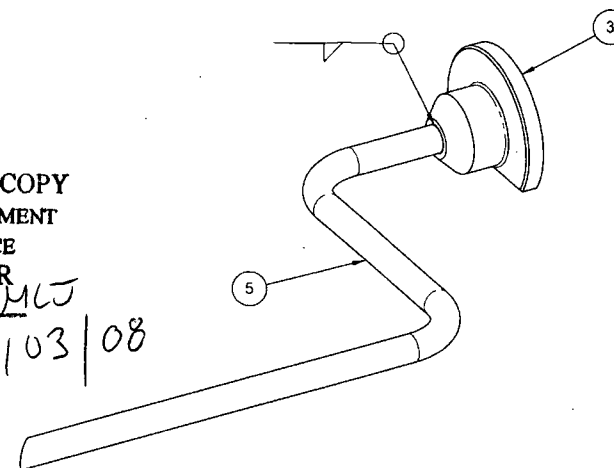


D4000-041 DRAIN FITTING ASSEMBLY, AFT

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4000-043/-045" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D4000-043 - 0.04 lbs
D4000-045 - 0.05 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81129 MLJ
12/03/08



D4000-043 DRAIN FITTING ASSEMBLY, FWD

RELEASED
2010-05-05
NMP

A	NEW ISSUE	BY	DATE
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4000	REV. A SHEET 1 OF 8
TITLE FITTING	SCALE NTS

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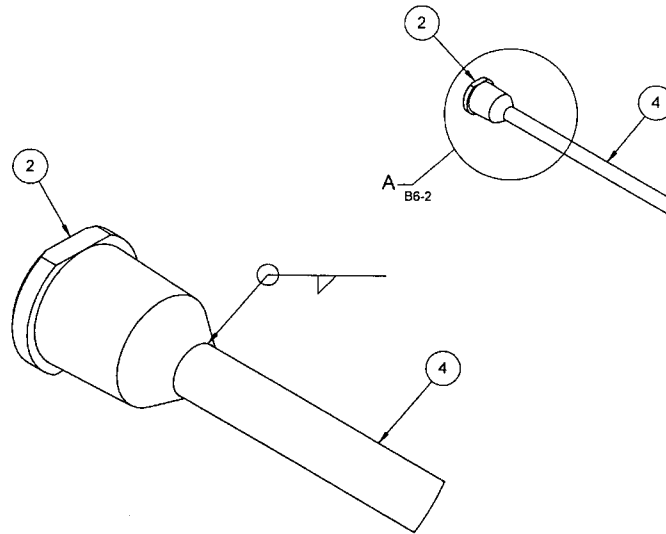
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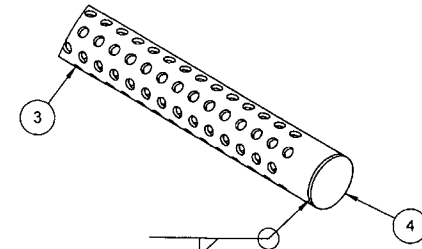
NOTE: Date & initial all entries

ITEM NO.	QTY. -047	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4000-045	FUEL PICK UP FITTING ASSEMBLY	JCA-M47-1-10
2	1	D4000-7	FUEL PICK UP FITTING	
3	1	D4000-11	CAP	
4	1	D4003-5	FUEL PICK UP LINE	

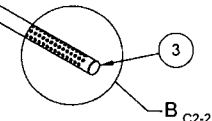


DETAIL A
SCALE 4X C6-2

D4000-045 FUEL PICKUP FITTING ASSEMBLY



DETAIL B
SCALE 4X B2-2



B C2-2

RELEASED
2010-05-05
MP

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4000-045" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.27 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4000	SHEET 2 OF 8
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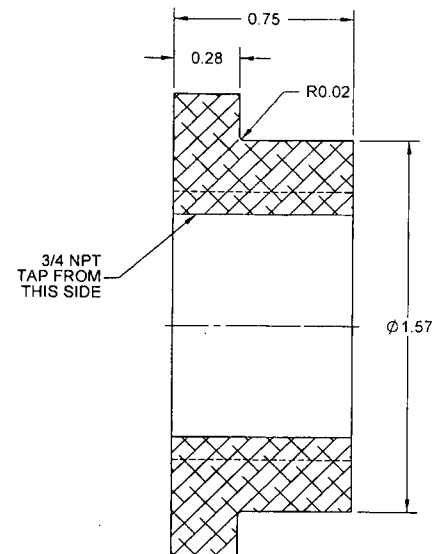
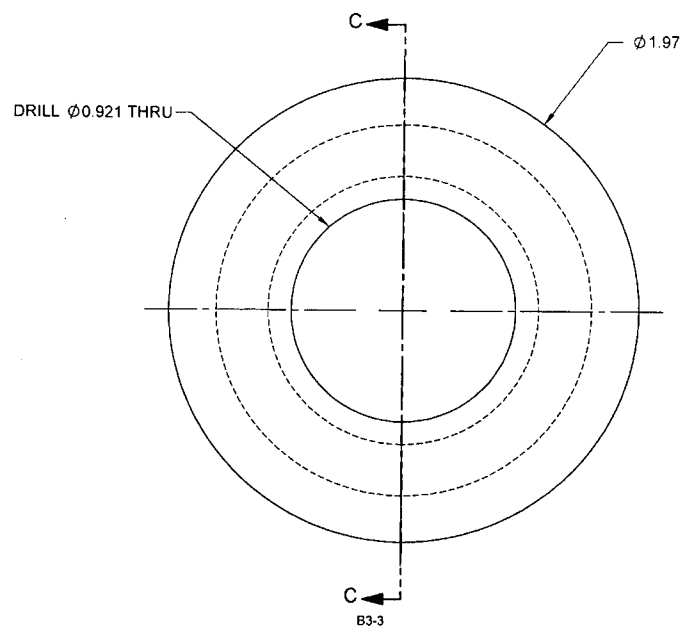
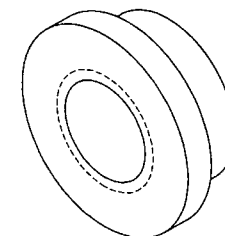
DART AEROSPACE
PART NUMBER

D4000-1

JOHN CAMERON AVIATION
PART NUMBER

JCA-M47-1-04

8/1/29



SECTION C-C
B6-3

D4000-1 FUEL SUPPLY FITTING

RELEASED
2010-05-05
mt

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
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MFG. APPR.	<i>JS</i>	D4000	SHEET 3 OF 8
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NOTE: Date & initial all entries

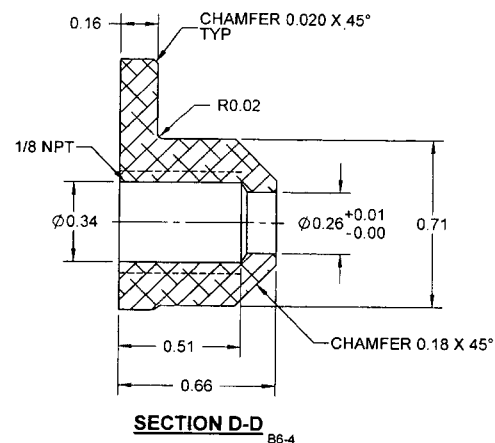
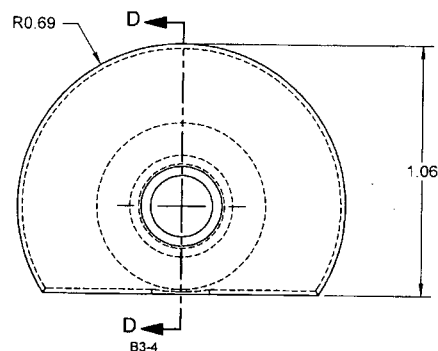
DART AEROSPACE
PART NUMBER

D4000-3

JOHN CAMERON AVIATION
PART NUMBER

JCA-M47-1-05

81129



D4000-3 FUEL SUMP DRAIN FITTING

RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4000	SHEET 4 OF 8
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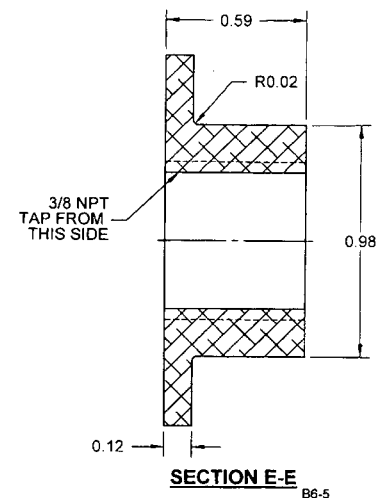
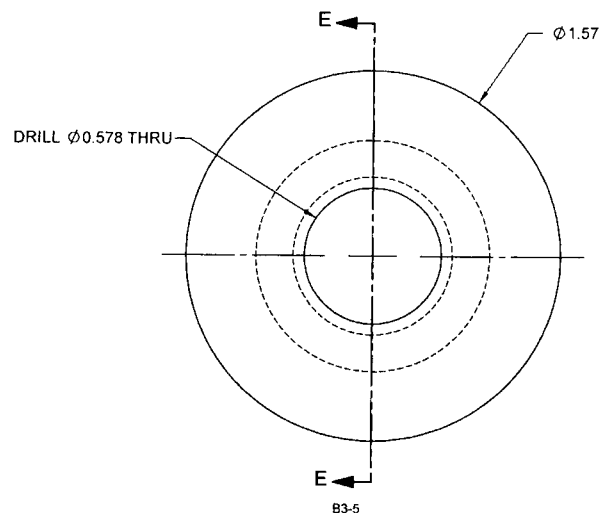
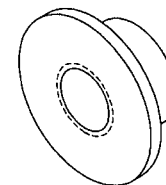
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-5	JCA-M47-1-09

81129



D4000-5 FUEL TANK VENT FITTING

RELEASED
2010-05-05
MD

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	<i>MD</i>	DART AEROSPACE LTD	
DRAWN	<i>MD</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MD</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MD</i>	D4000	SHEET 5 OF 8
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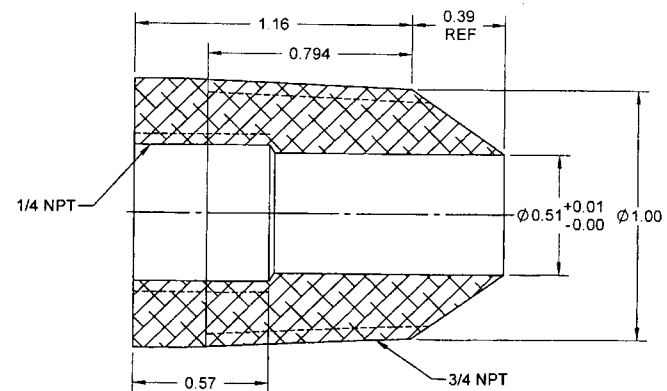
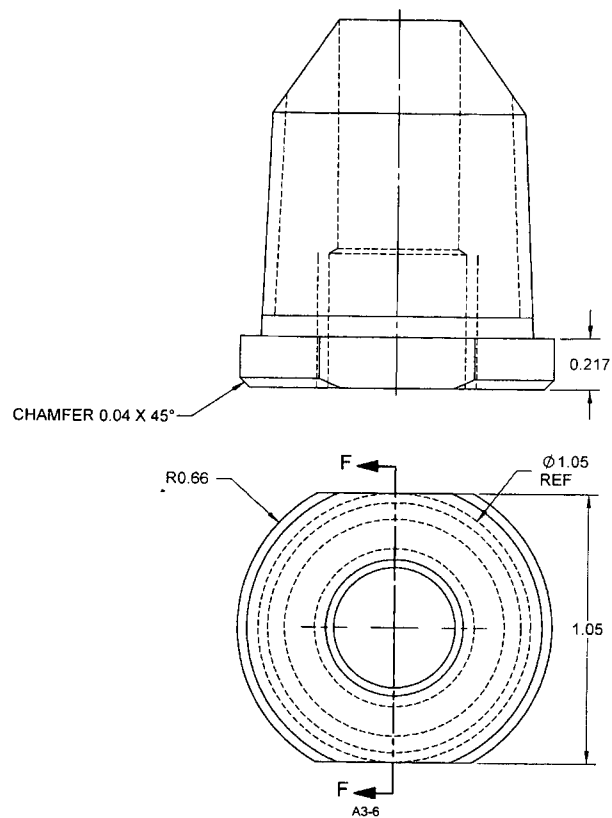
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-7	REF JCA-M47-1-10



SECTION F-F

A6-6

D4000-7 FUEL PICK UP FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4000	SHEET 6 OF 8
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RELEASED
2010-05-05

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DART AEROSPACE
PART NUMBER

D4000-9

JOHN CAMERON AVIATION
PART NUMBER

JCA-M47-1-11

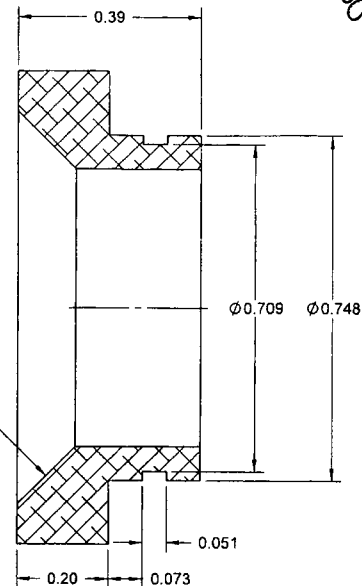
DRILL $\phi 0.60$ THRU

G

$\phi 1.02$

G
B3-7

0.13 x 45° CHAMFER



SECTION G-G

B6-7

D4000-9 GROMMET

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, $\phi 1.000$ ROUND BAR
REF DART SPEC M-DELRIN-R1.000
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4000	SHEET 7 OF 8
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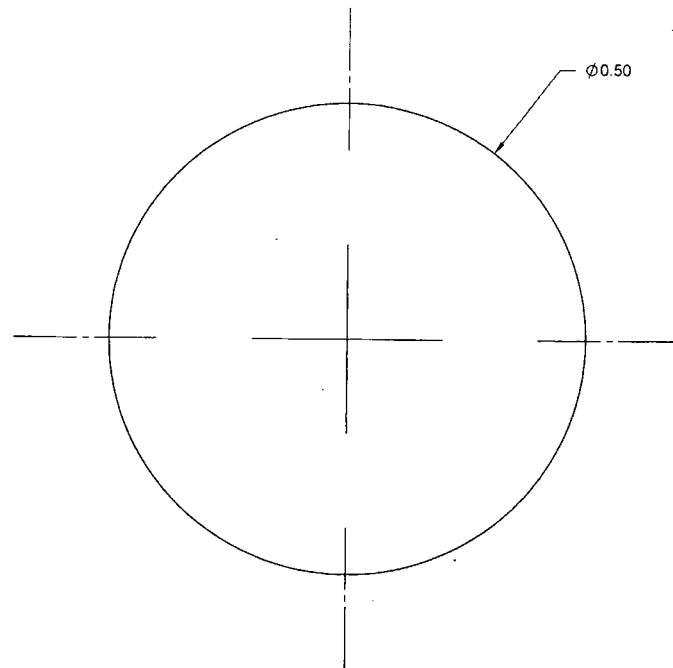
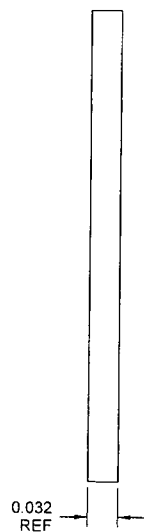
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81129



D4000-11 CAP

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4000	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		FITTING	NTS
DATE	10.02.10	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries